

# Work Order ID 92357

**\*92357\***

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October-30-12 9:13:23 AM

Item ID: D3859-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate  
 Start Date: 10/24/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 11/09/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: HLJ Date: 12-10-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3859	REV A								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3859 Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2- Deburr if necessary								
<u>304.063</u>									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
15  
12-11-05

6 B12-10-3

6 B12-11-3

6

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 Required Date: 11/09/12 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
*130*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod Batch: <u>M122257</u> 2-Weld hard facing as per Dwg D3859 A/R 2059B Hard Coat rod Batch: <u>M123667</u> *****use DT9462 for welding*****								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*140*									
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

6 12-11-16

6 12-11-19



6 12-11-19



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 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate  
 Start Date: 10/24/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 11/09/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
<div> <div> <b>Memo</b>                      START TIME: 12:00                      FINISH TIME: 3200F                 </div> <div>                     OVEN TEMPERATURE:                      12-30                 </div> </div>									
170 <b>*170*</b> QC Quality Control	QC3- Inspect Part Finish	0.00							
<div> <b>Memo</b>                      Identify as per dwg &amp; Stock Location: <u>ST 500</u> </div>									
180 <b>*180*</b> Packaging Packaging		0.00							

6X  12/11/21

6  12-11-21

6 12/11/21 JB

m122a66

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Revision ID: Stop **\*NS2\***  
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Required Date: 11/09/12 Req'd Qty: 4.00 **\*4\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*  
*mf*  
12-11-21

# Picklist Print

October-30-12 9:13:23 AM

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Work Order ID: 92357

Parent Item: D3859-041

Parent Item Name: Wearplate

Start Date: 10/24/12

Required Date: 11/09/12

Start Qty: 4.00

Required Qty: 4.00

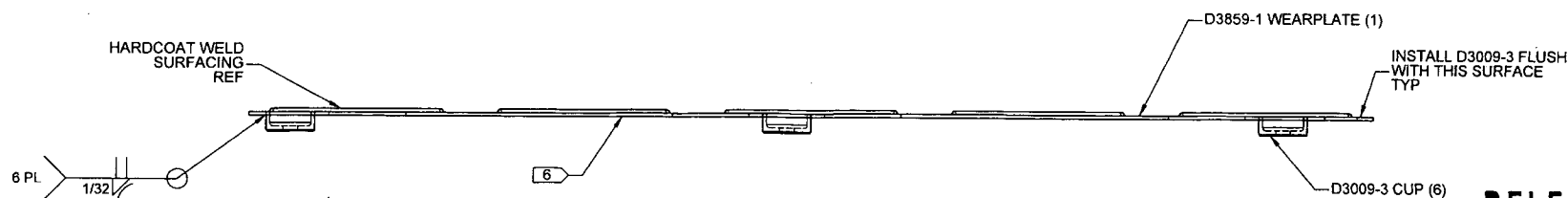
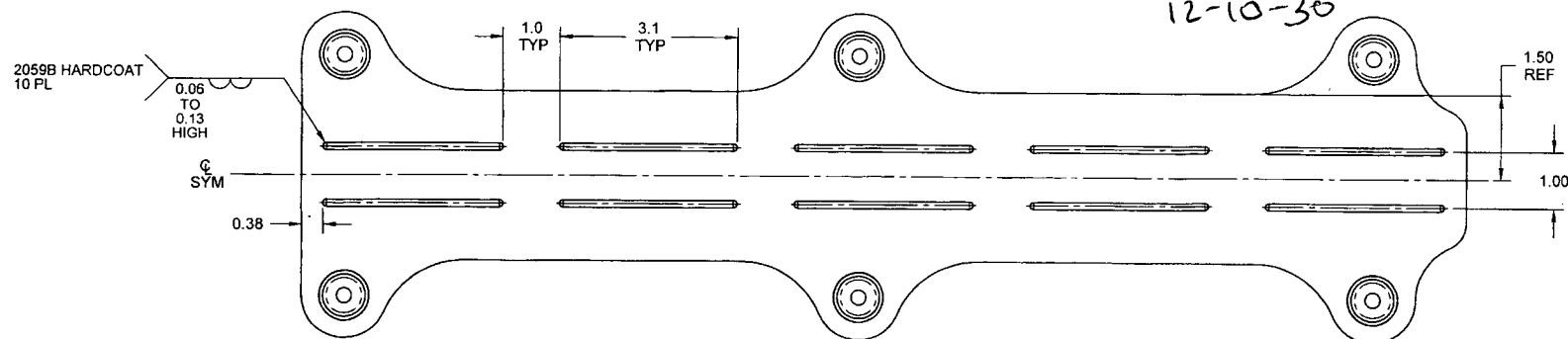
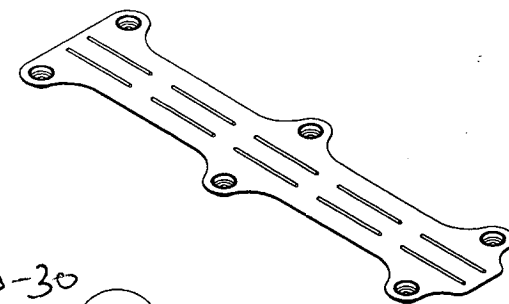
Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	398.6780	0.85	3.4	5	11-2-11-3	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		398.678							
				122245		51.078							
				122753		53.9							
				123136		293.7							
D3009-3 Cup		Manufactured	No			130	Each	34.0000	6	24	12-11-16		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		34							
				79078		30							
				88386		4							
				86809		124							



ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 92357 MLC  
12-10-30



**D3859-041 WEARPLATE**

**RELEASED**  
# 09 01.26

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.46 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.26		

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3859**

TITLE **WEARPLATE**

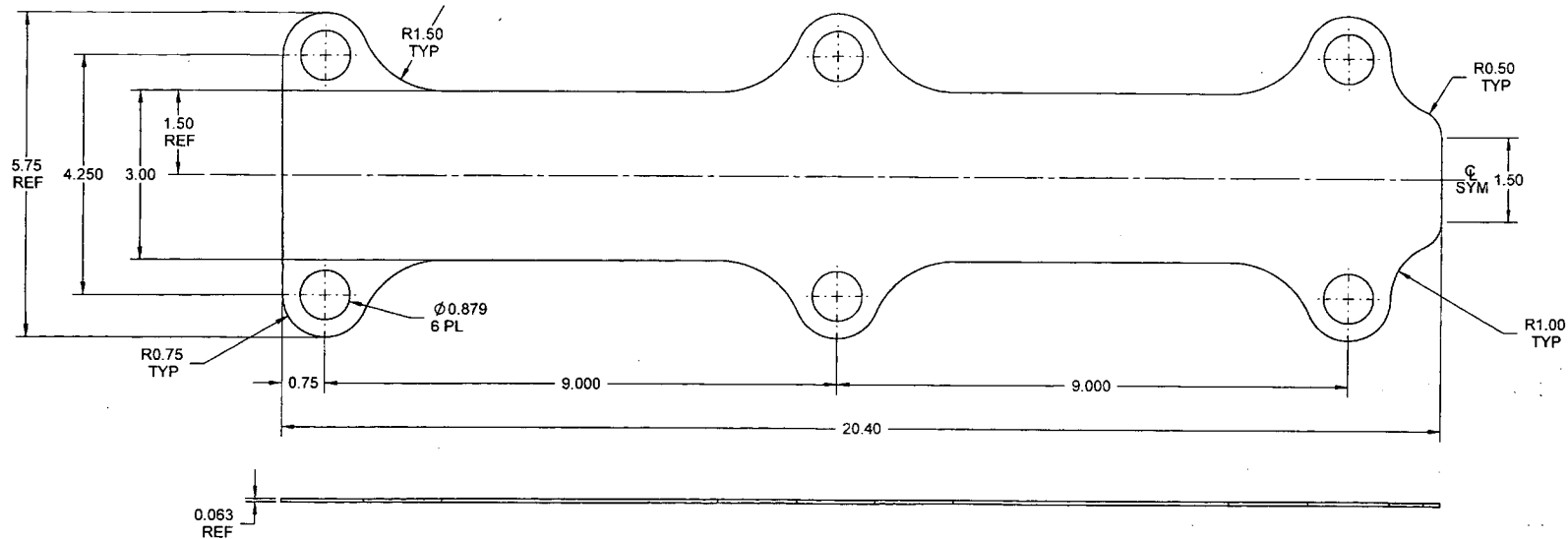
SCALE **NTS**

REV. A SHEET 1 OF 2

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92357



**D3859-1 WEARPLATE**

**RELEASED**  
11 09.01.26

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.29 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3859	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	09.01.26	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	